



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-636-011
Job Sheet 176611



Part No: D350-636-011

Job Qty: 1 ea

Part Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/26/18

Job Tracking No:

Due Date: 5/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D2750-041 REV G SHEETS 1,2,4,8 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13
As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD
verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP
Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R
13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/21/18	5/21/18	0.00	0.00	Start Up Skidtubes-1		OB
110	Skidtubes	1 pcs	5/21/18	5/21/18	0.00	4.55	Skidtubes-4		OB BE
120	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC10		P
130	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC5		B
140	HandFinish	1 pcs	5/21/18	5/21/18	0.00	0.93	HandFinish1		SA 18-06-07
150	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC7-2		BE
160	Skidtubes	1 pcs	5/21/18	5/21/18	0.00	4.55	Skidtubes-4		OB BE
170	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC10		38 DAS 9-88
180	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC5		38
190	HandFinish	1 pcs	5/21/18	5/21/18	0.00	0.93	HandFinish2		SA 18-06-25
200	SprayPaint	1 pcs	5/21/18	5/21/18	0.00	0.91	Spray Paint		AB JUN 18 2018
205	Outsource	1 pcs	5/21/18	5/21/18			ATE003-VC		N/R
210	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC14		18-6-22
230	HandFinish	1 pcs	5/21/18	5/21/18	0.00	0.93	HandFinish4		DAS
240	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC5		38
250	Packaging	1 pcs	5/21/18	5/21/18	0.00	0.00	Packaging1-3		JUN 28 2018
260	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC4		SAB DAS
265	DC	1 pcs	5/21/18	5/21/18	0.00	0.00	DC		JAB 28
270	Packaging	1 pcs	5/21/18	5/21/18	0.00	0.00	Packaging3-1		9-89
280	QC21-FG	1 Ea	5/21/18	5/21/18	0.00	0.00	QC21		DAS 21 JUN 28 2018

Fy072

Part Op 110 - Pick D2600-3 Bent Debur FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
Descriptions: D2750-1 Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B) 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 6-Open up holes of Detail A to 0.297" (total of 2 holes per side) 7-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 138834 8-Grind welds flush as per Dwg D2750
160 - 1-Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float

Work Order update only

H:/FORMS/Quality Assurance/approved QA/NCRWO Rev 1

hole using un-bit to 0.500" (4 per side) 4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5-Debur and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 138787 exp. date: 2008/10/01 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 138834 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12-Debur holes, ensure tube is free of all scratches before sending to paint.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 138862 2-

PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 138863

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: M138797 EXP DATE: 19/11/12 4-

Assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: M139842 5- Coat all exposed fasteners with "LPS Procyon" batch: M13264

260 - *****ensure antiseize is on AN8C21A bolts*****

265 - record fwd angle: 89.9 Photocopy blue file and type labels per PPP D350-636-011 CHG 007

270 - Package as per PPP D350-636-011 Location : FG072

004010

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 Ea (1 ea)	90-Start up Operation	5073156
D2744	Cap	1 Ea (1 ea)	90-Start up Operation	5063602
D2739	350 I-Beam	1 Ea (1 ea)	160-Skidtubes	5049038
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skidtubes	5051803
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5065863
D3490-3	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5066254
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish	5057157
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	5076000
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	5006333-1
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	5082489(x2)
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	5070858
D3488-041	Blade Fitting LH	1 Ea (1 ea)	230-HandFinish	5077552
D3492-1	Plug	8 Ea (8 ea)	230-HandFinish	5072782
D3492-3	Plug	8 Ea (8 ea)	230-HandFinish	5080747
D3535-25	Wearplate Center	1 Ea (1 ea)	230-HandFinish	5081731
D3536-25	Gasket Center	1 Ea (1 ea)	230-HandFinish	5070788
D3537-1	Wearpad	3 Ea (3 ea)	230-HandFinish	5058407
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	5059894
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	5072081
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish	5070839
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish	5059813
D3794-1	Gasket Fwd	1 Ea (1 ea)	230-HandFinish	5046513
D3794-3	Gasket Aft	1 Ea (1 ea)	230-HandFinish	5076009
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5050046-1
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5056493
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	M1138464-121
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	5036714
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5022092
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish	5034167
NAS1611-013	O-Ring	8 Ea (8 ea)	230-HandFinish	
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	FM137162
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging	5040882
D3493-1	Washer	2 Ea (2 ea)	250-Packaging	5067105
D3532-1	Spacer	2 Ea (2 ea)	250-Packaging	5062610
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5050046
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	FM25635

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-LH	1	3	0

160-Skiddtubes	D2744	1	87	0
	D2739	1	16	0
	D2743	8	134	0
	D3490-1	4	28	0
230-HandFinish	D3490-3	4	11	0
	ALS4-1032-225	38	5,580	0
	AN3C5A	34	1,993	0
	AN3C6A	4	286	0
	AN6C44A	4	363	0
	AN8C35A	1	52	0
	D2745	8	137	0
	D3488-041	1	5	0
	D3492-1	8	120	0
	D3492-3	8	45	0
	D3535-25	1	27	0
	D3536-25	1	35	0
	D3537-1	3	126	0
	D3631-1	8	955	0
	D3791-1	1	23	0
	D3793-1	1	11	0
	D3793-3	1	19	0
	D3794-1	1	24	0
	D3794-3	1	32	0
	MS21043-6	4	212	0
	MS21083C8	1	137	0
	NAS1149C0332R	38	6,209	0
	NAS1149C0832R	1	73	0
	NAS1515H3L	4	211	0
	NAS1611-010	8	601	0
	NAS1611-013	8	397	0
250-Packaging	AN8C21A	2	107	0
	D2741	1	54	0
	D3493-1	2	34	0
	D3532-1	2	46	0
	MS21083C8	2	137	0
	NAS1149D0863J	2	125	0

Part Specifications

Specifications could not be found.

PAGE 1 OF 1

Description: SKIDTUBE STD LH/RH, FLOAT COMPATIBLE

[illegible]